

(19)



Europäisches Patentamt

European Patent Office

Office européen des brevets



(11)

EP 0 659 117 B1

(12)

EUROPEAN PATENT SPECIFICATION

(45) Date of publication and mention
of the grant of the patent:
10.06.1998 Bulletin 1998/24

(21) Application number: **93920333.7**

(22) Date of filing: **25.08.1993**

(51) Int. Cl.⁶: **B32B 31/00, A61F 13/15**

(86) International application number:
PCT/US93/07992

(87) International publication number:
WO 94/05500 (17.03.1994 Gazette 1994/07)

(54) METHOD FOR CONTINUOUSLY ATTACHING A RESTRAINED ELASTIC MATERIAL TO AN ABSORBENT ARTICLE

VERFAHREN ZUM KONTINUIERLICHEN ANBRINGEN EINES VORGESPANNTEN ELASTISCHEN MATERIALS AN EINEN ABSORBIERENDEN GEGENSTAND

PROCEDE DE FIXATION D'UN MATERIAU ELASTIQUE RETENU A UN ARTICLE ABSORBANT

(84) Designated Contracting States:
AT BE CH DE ES FR GB IT LI LU NL SE

(30) Priority: **04.09.1992 US 941342**

(43) Date of publication of application:
28.06.1995 Bulletin 1995/26

(73) Proprietor:
THE PROCTER & GAMBLE COMPANY
Cincinnati, Ohio 45202 (US)

(72) Inventors:
• **MUCKENFUHS, Delmar, Ray**
Middletown, OH 45044 (US)

• **REIFENBERGER, John, Erwin**
Cincinnati, OH 45247 (US)

(74) Representative:
Hirsch, Uwe Thomas et al
Procter & Gamble European Service GmbH,
Sulzbacher Strasse 40-50
65824 Schwalbach am Taunus (DE)

(56) References cited:
EP-A- 0 047 106 **EP-A- 0 113 976**
WO-A-93/01784 **US-A- 4 023 571**
US-A- 4 863 542

EP 0 659 117 B1

Note: Within nine months from the publication of the mention of the grant of the European patent, any person may give notice to the European Patent Office of opposition to the European patent granted. Notice of opposition shall be filed in a written reasoned statement. It shall not be deemed to have been filed until the opposition fee has been paid. (Art. 99(1) European Patent Convention).

Description

FIELD OF THE INVENTION

The present invention pertains to individually wrapped disposable absorbent articles, and more particularly, to such individually wrapped disposable absorbent articles which restrain the elastic forces while wrapped and which free the elastic forces when unwrapped, allowing them to act on the absorbent article.

BACKGROUND OF THE INVENTION

All manner and variety of absorbent articles configured for the absorption of bodily fluids are, of course, well known. Current types of absorbent articles include sanitary napkins, pantliners, diapers, and incontinent articles.

Several prior art structures have been developed to improve the overall fit of absorbent articles so that they more readily conform to the contours of the human body. By improving the fit of the absorbent article, it is expected that the performance of the absorbent article will also improve. In some prior art sanitary napkins elastic has been placed along the lateral edges of the sanitary napkin. The elastic is contained within the material comprising the absorbent article and therefore is not visible to the consumer. The elastic provides the sanitary napkin with an upwardly cupped shape improving the overall fit of the sanitary napkin to the body. However, there are numerous packaging, transport and storage problems associated with articles having an upwardly cupped shape.

European patent applications EP-A-47106 and EP-A-113976, and US Patent No. 4,863,542 disclose methods for attaching elastic ribbons to absorbent articles. None of those prior art documents discloses a method that includes a wrapper material on a second assembly station, nor the articles made according to these methods can be packed, transported and stored in a substantially flat configuration, since the applied elastics provide them with a curved shape.

Other prior art sanitary napkins are of a substantially planar configuration making them easier to package, transport, and store. However, these prior art sanitary napkins remain in their substantially planar configuration throughout their use. While being easier to package, transport and store, the substantially planar sanitary napkin does not readily conform to the contours of the human body. According, the substantially planar sanitary napkin provides an overall fit which is perceived as less than desirable by some users who prefer the upwardly cupped configuration.

Accordingly, it is desirable to produce an individually wrapped absorbent article, e.g., sanitary napkin, which can be packaged, transported, and stored in a substantially planar or flat configuration and yet conform

substantially to the contours of the human body upon removal of the absorbent article from the package by the user.

SUMMARY OF THE INVENTION

The present invention provides a method for continuously attaching discrete segments of a tensioned elastic material to predetermined, isolated portions of moving absorbent articles, said absorbent articles having a topsheet, a backsheet, and an absorbent core. The method comprises the steps as disclosed in claims 1 and 9.

BRIEF DESCRIPTION OF THE DRAWINGS

While the specification concludes with claims particularly pointing out and distinctly claiming the subject matter of the present invention, it is believed that the present invention will be better understood from the following description and drawings, in which like reference numerals identify identical elements and wherein;

Figure 1 is a top plan view of a preferred sanitary napkin of the present invention with portions cut-away to more clearly show the construction of the sanitary napkin;

Figure 2 is a cross-sectional view of the sanitary napkin of Figure 1 taken along section line 2-2;

Figure 3 is a plan view illustrating the preferred placement of the elastic material on the backsheet of the sanitary napkin;

Figure 4 is a plan view illustrating the preferred placement of the restraint material on the wrapper; Figure 5 is a partially cut-away perspective view of a sanitary napkin and its associated wrapper after they have been folded and sealed;

Figure 6 is a perspective view of a sanitary napkin after its associated wrapper has been removed;

Figure 7 is a perspective view of the sanitary napkin and its associated wrapper after they have been folded and sealed;

Figure 8 is a perspective view of the sanitary napkin and its associated wrapper in a partially opened position;

Figure 9 is a cross-sectional view of another embodiment of a sanitary napkin of the present invention;

Figure 10 is a top plan view of another embodiment of a sanitary napkin of the present invention;

Figure 11 is a cross-sectional view of the sanitary napkin of Figure 10 taken along section line 11-11;

Figure 12 is a top plan view of another embodiment of a sanitary napkin of the present invention;

Figure 13 is cross-sectional view of the sanitary napkin of Figure 12 taken along section line 13-13;

Figure 14 is a simplified sectional side elevation view showing the assembly of sanitary napkins of

the present invention; and

Figure 15 is a simplified sectional scale elevation view showing the assembly of sanitary napkins of the present invention.

DETAILED DESCRIPTION OF THE INVENTION

1. General Description of the Absorbent Article

As used herein, the term "absorbent article" refers to devices which absorb and contain body exudates, and, more specifically, refers to devices which are placed against or in proximity to the body of the wearer to absorb and contain the various exudates discharged from the body. The term "absorbent article" is intended to include diapers, catamenial pads, sanitary napkins, pantliners, incontinent pads, and the like. The term "disposable" is used herein to describe absorbent articles which are not intended to be laundered or otherwise restored or reused as an absorbent article (i.e., they are intended to be discarded after a single use, and, preferably, to be composted or otherwise disposed of in an environmentally compatible manner). A "unitary" absorbent article refers to absorbent articles which are formed of separate parts united together to form a coordinated entity so that they do not require separate manipulative parts like a separate holder and pad.

A preferred embodiment of a unitary disposable absorbent article of the present invention is the catamenial pad, sanitary napkin 20, shown in Figure 1. As used herein, the term "sanitary napkin" refers to an absorbent article which is worn by females adjacent to the pudendal region, generally external to the urogenital region, and which is intended to absorb and contain menstrual fluids and other vaginal discharges from the wearer's body (e.g., blood, menses, and urine). Interlabial devices which reside partially within and partially external of the wearer's vestibule are also within the scope of this invention. As used herein, the term "pudendal" refers to the externally visible female genitalia. It should be understood, however, that the present invention is also applicable to other feminine hygiene or catamenial pads such as pantliners, or other absorbent articles such as incontinence pads, and the like.

The sanitary napkin 20 has two surfaces, a body-contacting surface or "body surface" 20a and a garment surface 20b. The sanitary napkin 20 is shown in Figure 1 as viewed from its body surface 20a. The body surface 20a is intended to be worn adjacent to the body of the wearer. The garment surface 20b of the sanitary napkin 20 (shown in Figure 2) is on the opposite side and is intended to be placed adjacent to the wearer's undergarments when the sanitary napkin 20 is worn.

The sanitary napkin 20 has two centerlines, a longitudinal centerline "l" and a transverse centerline "t". The term "longitudinal", as used herein, refers to a line, axis or direction in the plane of the sanitary napkin 20 that is generally aligned with (e.g., approximately parallel to) a

vertical plane which bisects a standing wearer into left and right body halves when the sanitary napkin 20 is worn. The terms "transverse" or "lateral" as used herein, are interchangeable, and refer to a line, axis or direction which lies within the plane of the sanitary napkin 20 that is generally perpendicular to the longitudinal direction.

Figure 1 is a top plan view of the sanitary napkin 20 and a wrapper 30 of the present invention in its flat state with portions of the structure being cut-away to more clearly show the construction of the sanitary napkin 20 and with the portion of the sanitary napkin 20 which faces or contacts the wearer 20a, oriented towards the viewer. As shown in Figure 1, the sanitary napkin 20 preferably comprises a liquid pervious topsheet 22, a liquid impervious backsheet 23 joined with the topsheet 22, and an absorbent core 24 positioned between the topsheet 22 and the backsheet 23.

The sanitary napkin 20 can also be provided with one or more addition layers or components. These include an acquisition layer (or the "secondary topsheet") 25 positioned generally between the topsheet 22 and the absorbent core 24. The sanitary napkin 20 also includes a nonwoven layer 26 positioned between the absorbent core 24 and the backsheet 23. The nonwoven layer 26 serves to keep the material of the absorbent core 24 from tearing (when the core is comprised of a cross-linked cellulose fibers) and the layers of the sanitary napkin 20 are stitched.

The sanitary napkin 20 has a perimeter generally comprising longitudinal perimeter segments 32 and transverse perimeter segments 34. The perimeter defines the outer boundary of the sanitary napkin 20, while the longitudinal perimeter segments 32 and the transverse perimeter segments 34 define the outer boundary of the sanitary napkin 20 along each longitudinal side and each transverse end respectively.

Figure 2 is a cross-sectional view of the sanitary napkin 20 taken along section line 2-2 of Figure 1. As can be seen in Figure 2 the sanitary napkin 20 includes an adhesive element 28. The adhesive element 28 is positioned on the outwardly oriented face of backsheet 23, and, in use, serves to affix the sanitary napkin 20 to the wearer's undergarments, thereby maintaining the sanitary napkin 20 in place against the wearer's body. The adhesive element 28 may take the form of a coating of adhesive which is in strips or any other suitable pattern. Preferably the backsheet 23 is coated uniformly with a layer of pressure sensitive hot melt adhesive such as NS34-2823 as manufactured by National Starch and Chemical of Bridgewater, NJ.

The sanitary napkin 20 preferably includes two discrete segments of elastic material 50 attached to the outwardly oriented face or the garment facing surface of the backsheet 23. Releasably secured to the two discrete segments of elastic material 50 are two discrete segments of restraint material 52. The restraint material 52 releasably secures the elastic material 50 in a sub-

stantially tensioned state until separation of the elastic material 50 from the restraint material 52, whereupon the tension in the elastic material 50 is released.

Figure 9 is a cross-sectional view of another embodiment of a sanitary napkin 20 of the present invention. As can be seen in Figure 9 sanitary napkin 20 preferably comprises a liquid pervious topsheet 22, a liquid impervious backsheet 23 joined with the topsheet 22, and an absorbent core 24 positioned between the topsheet 22 and backsheet 23. The sanitary napkin 20 also includes an acquisition layer 25 positioned generally between the topsheet 22 and the absorbent core 24. The sanitary napkin 20 also includes a nonwoven layer 26 positioned between the absorbent core 24 and the backsheet 23. The sanitary napkin 20 also includes an adhesive element 28 positioned on the outwardly oriented face of the backsheet 23. A wrapper 30 is releasably affixed to the adhesive element 28.

The sanitary napkin 20 preferably includes two discrete segments of elastic material 50 permanently attached to the outwardly oriented face or the garment facing surface of the backsheet 23. The wrapper 30 is preferably releasably secured to the two discrete segments of elastic material 50. The wrapper 30 preferably maintains the elastic material 50 in a substantially tensioned state until separation of the wrapper 30 from the elastic material 50, whereupon the tension in the elastic material 50 is released.

Figure 10 is a top plan view of another embodiment of a sanitary napkin 20 and a wrapper 30 of the present invention in its flat state with portions of the structure being cut-away to more clearly show the construction of the sanitary napkin 20 and with the portion of the sanitary napkin 20 which faces or contacts the wearer 20a, oriented towards the viewer. As shown in Figure 10, the sanitary napkin 20 preferably comprises a liquid pervious topsheet 22, a liquid impervious backsheet 23 joined with the topsheet 22, and an absorbent core 24 positioned between the topsheet 22 and the backsheet 23. The sanitary napkin 20 also includes an acquisition layer 25 positioned generally between the topsheet 22 and the absorbent core 24. The sanitary napkin 20 preferably includes two discrete segments of elastic material 50 attached to the body facing surface of the backsheet 23 and to the longitudinal segments of the absorbent core 24.

Figure 11 is a cross-section view of the sanitary 20 taken along section line 11-11 of Figure 10. As can be seen in Figure 11 the sanitary napkin 20 includes an adhesive element 28 positioned on the garment facing surface of the backsheet 23.

The wrapper 30, which is releasably affixed to the outer or garment facing surface of the backsheet 23 maintains the elastic material 50 in a substantially tensioned state until separation of the wrapper 30 from the backsheet 23, whereupon the tension in the elastic material 50 is released. Preferably, the wrapper 30 includes stiffening members 31 on its inwardly oriented

faces. Stiffening members 31 provide the wrapper 30 with additional support to maintain the elastic material 50 in a substantially tensional state until separation of the wrapper 30 from the backsheet 23.

Figure 12 is a top plan view of an alternative embodiment of a sanitary napkin 20 and a wrapper 30 of the present invention in its flat-out state with portions of the structure being cut-away to more clearly show the construction of the sanitary napkin 20 and with the portion of the sanitary napkin 20 which faces or contacts the wearer 20a oriented towards the viewer. As shown in Figure 12, the sanitary napkin 20 preferably comprises a liquid pervious topsheet 22, a liquid impervious backsheet 23 joined with the topsheet 22, and an absorbent core 24 positioned between the topsheet 22 and the backsheet 23. The sanitary napkin 20 also includes an acquisition layer 25 positioned generally between the topsheet 22 and the absorbent core 24. The sanitary napkin 20 preferably includes two discrete segments of elastic material 50 attached to the body facing surface of the backsheet 23. In addition, the sanitary napkin 20 preferably includes two additional discrete segments of elastic material 51 also attached to the body facing surface of the backsheet 23.

Figure 13 is cross-sectional view of the sanitary napkin 20 taken along section line 13-13 of Figure 12. As can be seen in Figure 13 the sanitary napkin 20 includes an adhesive element 28. The adhesive element 28 is positioned on the outwardly oriented face of the backsheet 23, and, in use, serves to affix the sanitary napkin 20 to the wearer's undergarments, thereby maintaining the sanitary 20 in place against the wearer's body. A release paper 29 is preferably positioned between the backsheet 23 and the wrapper 30.

The wrapper 30 maintains the discrete segments of the elastic material, 50 and 51, in a substantially tensioned state until separation of the wrapper 30 from the backsheet 23, whereupon the tension in the elastic material, 50 and 51, is released. Preferably, the wrapper 30 includes stiffening portions 30a. Stiffening portions 30a are thick portions of wrapper material which provide the additional support to maintain the elastic material, 50 and 51, in a substantially tensioned state until separation of the wrapper 30 from the backsheet 23.

The individual components of the sanitary napkin will now be looked at in greater detail.

2. Individual Components of the Sanitary Napkin

A. The Topsheet

The topsheet 22 is compliant, soft feeling, and non-irritating to the wearer's skin. Further, the topsheet 22 is liquid pervious permitting liquids (e.g., menses and/or urine) to readily penetrate through its thickness. A suitable topsheet 22 may be manufactured from a wide range of materials such as woven and nonwoven materials; polymeric materials such as apertured formed

thermoplastic films, apertured plastic films, and hydro-formed thermoplastic films; porous foams; reticulated foams; reticulated thermoplastic films; and thermoplastic scrims. Suitable woven and nonwoven materials can be comprised of natural fibers (e.g., wood or cotton fibers), synthetic fibers (e.g., polymeric fibers such as polyester, polypropylene, or polyethylene fibers) or from a combination of natural and synthetic fibers.

A preferred topsheet 22 comprises an apertured formed film. Apertured formed films are preferred for the topsheet because they are pervious to body exudates and yet non-absorbent and have a reduced tendency to allow liquids to pass back through and rewet the wearer's skin. Thus, the surface of the formed film which is in contact with the body remains dry, thereby reducing body soiling and creating a more comfortable feel for the wearer. Suitable formed films are described in U.S. Patent 3,929,135, issued to Thompson on December 30, 1975; U.S. Patent 4,324,246, issued to Mullane et al. on April 13, 1982; U.S. Patent 4,342,314, issued to Radel et al. on August 3, 1982; U.S. Patent 4,463,045, issued to Ahr et al. on July 31, 1984; U.S. Patent 4,629,643, issued to Curro et al. on December 16, 1986; and U.S. Patent 5,006,394, issued to Baird on April 9, 1991. The preferred topsheet 22 for the present invention is the formed film described in one or more of the above patents and marketed on sanitary napkins by The Procter & Gamble Company of Cincinnati, Ohio as "DRI-WEAVE".

In a preferred embodiment of the present invention, the body surface of the formed film topsheet 22 is hydrophilic so as to help liquid to transfer through the topsheet 22 faster than if the body surface was not hydrophilic. This will diminish the likelihood that menstrual fluid will flow off the topsheet 22 rather than flowing into and being absorbed by the absorbent core 24. In a preferred embodiment, surfactant is incorporated into the polymeric materials of the formed film topsheet 22 such as is described in WO-A-93/09741, entitled "Absorbent Article Having A Nonwoven and Apertured Film Coversheet" filed on November 19, 1991 by Aziz et al. Alternatively, the body surface of the topsheet 22 can be made hydrophilic by treating it with a surfactant such as is described in U.S. Patent 4,950,264 issued to Osborn on August 21, 1991 and U.S. Patent 5,009,653, issued to Osborn on April 23, 1991.

B. The Absorbent Core

The absorbent core 24 may be any absorbent means which is capable of absorbing or retaining liquids (e.g., menses and/or urine). As shown in Figure 2, the absorbent core 24 has a body surface, a garment surface, side edges, and end edges. The absorbent core 24 may be manufactured in wide variety of sizes and shapes (e.g., rectangular, oval, hourglass, dog bone, asymmetric, etc.) and from a wide variety of liquid-absorbent materials commonly used in sanitary napkins

and other absorbent articles such as comminuted wood pulp which is generally referred to as airfelt. An example of other suitable absorbent materials include creped cellulose wadding; meltblown polymers including coform; chemically stiffened, modified or cross-linked cellulosic fibers; capillary channel fibers; synthetic fibers such as crimped polyester fibers; peat moss; tissue including tissue wraps and tissue laminates; absorbent foams; absorbent sponges; superabsorbent polymers; absorbent gelling materials; or any equivalent material or combinations of materials, or mixtures of these.

The configuration and construction of the absorbent core 24 may also be varied (e.g., the absorbent core may have varying caliper zones (e.g., profiled so as to be thicker in the center), hydrophilic gradients, superabsorbent gradients, or lower density and lower average basis weight acquisition zones; or may comprise one or more layers or structures). The total absorbent capacity of the absorbent core 24 should, however, be compatible with the design loading and the intended use of the sanitary napkin 20. Further, the size and absorbent capacity of the absorbent core 24 may be varied to accommodate different uses such as incontinence pads, pantliners, regular sanitary napkins, or overnight sanitary napkins.

Exemplary absorbent structures for use as the absorbent core 24 of the present invention are described in U.S. Patent 4,950,264, issued to Osborn on August 21, 1990; U.S. Patent 4,610,678, issued to Weisman et al. on September 9, 1986; U.S. Patent 4,834,735, issued to Alemamy et al. on May 30, 1989; U.S. Patent 5,009,653, issued to Osborn on April 23, 1991; and European Patent Application No. 0 198 683, The Procter & Gamble Company, published October 22, 1986 in the name of Duenk et al.

A preferred embodiment of the absorbent core 24 comprises the laminate structure shown in Figure 2. The laminate is comprised of a layer of superabsorbent polymeric (or absorbent gelling material) and one or more sheets or webs of cross-linked cellulosic fibers. Suitable cross-linked cellulosic fibers for the absorbent core 24 are described in U.S. Patent 4,888,093 issued to Cook et al. on December 19, 1989; U.S. Patent 4,822,543, issued to Dean et al. on April 18, 1989; U.S. Patent 4,889,595, issued to Schoggen et al. on December 26, 1989; and U.S. Patent 4,898,642, issued to Moore et al. on February 6, 1990; U.S. Patent 4,935,022, issued June 19, 1990 to Lash et al.; EPO Patent Application Publication Nos. 0 427 316 A2 and 0 427 317 A2 published in the name of Herron et al. on May 15, 1991; and EPO Patent Application Publication No. 0 429 112 A2 published in the name of Herron et al. on May 29, 1991.

The cross-linked cellulosic fibers in the embodiment shown in Figure 2 comprises a single sheet that wraps the layers of particles of absorbent gelling material 40. The sheet is wrapped so that it appears as having a "c" configuration when viewed from the end. The

wrapped sheet forms an upper layer 41 and a lower layer 42. In alternative embodiments, the laminate can be formed in many other manners, such as by providing separate webs of cross-linked cellulosic material (or other absorbent material) for the different layers of the absorbent core laminate other than a single sheet, or by providing it with additional layers.

In this type of core, curled, twisted, preferably chemically stiffened and cross-linked, cellulose fibers are refined to provide fibers which can be used in sheet form as the absorbent core. The preparation of suitable curled, chemically stiffened cellulosic fibers from which one can prepare the refined, curled, chemical stiffened cellulosic fibers used in detail in U.S. Patents 4,888,903; 4,822,543; 4,889,595; 4,889,597; 4,889,596; and 4,898,642.

The use of such fibers in combination with absorbent gelling materials, and means for manufacturing such combinations, are described in U.S. Patent 4,935,022. Such preparations typically involve the use of aldehydes, such as glutaraldehyde, as crosslinking agents. In addition, polycarboxylic acids can be used as crosslinking agents. It will be appreciated that other means for preparing other crosslinked cellulosic fibers are also known, and such fibers may also be used herein, although the fluid absorbency properties may be suboptimal as compared with the above-mentioned fibers. Reference can be made to the various citations in U.S. Patent 4,898,642 and PCT U.S. 89 01581 for other fiber types. Once in hand, the curled cellulosic fibers are refined to provide the fibers used to prepare the preferred absorbent cores used in the practice of this invention.

C. Backsheet

The backsheet 23 is impervious to liquids (e.g., menses and/or urine) and is preferably manufactured from a thin plastic film, although other flexible liquid impervious materials may also be used. As used herein, the term "flexible" refers to materials which are compliant and will readily conform to the general shape and contours of the human body. The backsheet 23 prevents the exudates absorbed and contained in the absorbent core 24 from wetting articles which contact the sanitary napkin 20 such as pants, pajamas and undergarments. The backsheet 23 may thus comprise a woven or nonwoven material, polymeric films such as thermoplastic films of polyethylene or polypropylene, or composite materials such as a film-coated nonwoven material. Preferably, the backsheet 23 is a polyethylene film having a thickness of from about 0.012 mm (0.5 mil) to about 0.051 mm (2.0 mils). Exemplary polyethylene films are manufactured by Clorox Corporation of Cincinnati, Ohio, under the designation P18-0401 and by Ethyl Corporation, Visqueen Division, of Terre Haute, Indiana, under the designation XP-39385. The backsheet 23 is preferably embossed and/or matte finished

to provide a more clothlike appearance. Further, the backsheet 23 may permit vapors to escape from the absorbent core 24 (i.e., breathable) while still preventing exudates from passing through the backsheet 23.

D. The Wrapper

A wrapper 30 is associated with, and has dimensions generally larger than those of the sanitary napkin 20. Thus, the wrapper 30 has longitudinal flap portions 36 comprising that portion of the wrapper 30 between the longitudinal edges 35 of the wrapper 30 and the longitudinal perimeter segments 32 of the sanitary napkin 20. In the preferred embodiment illustrated in Figure 1, the wrapper 30 also has transverse flap portions 38 comprising that portion of the wrapper 30 between the transverse edges 37 of the wrapper 30 and transverse segments 34 of the sanitary napkin 20.

The wrapper 30 has opposed faces. One face is an inwardly oriented face which is oriented towards the adhesive 28 and the outwardly oriented face of the backsheet 23. The other face is an outwardly oriented face opposed to the inwardly oriented face and which is oriented away from the sanitary napkin 20. Preferably, the inwardly oriented face is release coated, to facilitate easy and convenient release of the wrapper 30 from the adhesive 28 on backsheet 23. In other words, the wrapper 30 is releasably affixed to the adhesive element 28. As used herein, "releasably affixed" refers to the condition of two or more components which may be attached and separated without destruction or undue distortion of either component. As discussed earlier herein, the adhesive 28 serves to affix the sanitary napkin 20 to the wearer's undergarments, thereby maintaining the sanitary napkin 20 in place against the wearer's body. The wrapper 30 protects the adhesive 28 from contamination or from sticking to areas other than those desired prior to use.

Silicon releases, as are well known in the art, have been found to work well. The wrapper 30 may be zone coated with the release coating only in the areas of the adhesive 28, or may be entirely release coated throughout the inwardly oriented face as desired. The wrapper 30 may be manufactured from films, paper, or other materials as are well known in the art. Preferably, the wrapper 30 is a polyethylene film having a thickness of from about 0.012 mm (0.5 mil) to about 0.12mm (5.0 mil).

The wrapper 30 overlays the outwardly oriented face of backsheet portion 23 with the longitudinal flap portions 36 extending beyond the longitudinal perimeter segments 32. It is important to note that the wrapper 30 is not folded onto or otherwise brought into contact with the topsheet portion 22 while sanitary napkin 20 is in a substantially flat configuration as shown in Figure 1. In other words, the inwardly oriented face of the wrapper 30 facing the backsheet portion 23 is in face to face relation with the backsheet portion only. However, upon

folding of the wrapper 30 and sanitary napkin 20, the wrapper 30 will come into contact with portions of the topsheet 22.

An example of a suitable wrapper 30 is disclosed in commonly assigned U.S. Patent 4,556,146 issued to Swanson et al. on December 3, 1985, which patent is incorporated herein by reference.

Referring now to Figure 11, the wrapper 30 preferably includes stiffening members 31 on its inwardly oriented face. The stiffening members 31 provide wrapper 30 with additional support in order to maintain the elastic material 50 in a substantially tensioned state until separation of the wrapper 30 from the backsheet 23. Preferably, the stiffening members 31 are made of polyethylene. Other suitable materials for stiffening members 31 include but are not limited to polyester, polyethylene terephthalate (PET), glycol modified PET copolymer (PETG) polystyrene, blends of polystyrene, polyethylene laminated to paper, paper paperboard and cardboard.

As can be seen in Figure 13 the wrapper 30 preferably includes stiffening portions 30a. Stiffening portions 30a are thick portions of wrapper material which provide the additional support needed to maintain the elastic material, 50 and 51, in a substantially tensioned state until separation of the wrapper 30 from the backsheet 23. Preferably the stiffening portions 30a are portions of wrapper material 30 which have been extruded at a thicker level than that of the remaining portions of the wrapper 30.

A sheet of release paper 29 is preferably positioned between the wrapper 30 and the backsheet 23. The release paper 29 is permanently secured to the inwardly oriented face of the wrapper 30 by an adhesive. The body facing surface of release paper 29 is release coated to facilitate easy and convenient release of the release paper 29 from the adhesive 28 on backsheet 23. That is, the release paper 29 is releasably affixed to the adhesive element 28.

E. The Adhesive Tab

As illustrated in Figures 7 and 8, a securement means is preferably provided on the outwardly oriented face of the wrapper 30. The securement means may be any means which will initially secure the package at the time of manufacture and maintain the package in a secured condition until it is opened by the consumer. In addition, the securement means will allow the user to reclose the package after use. An example of a suitable adhesive tab construction is disclosed in commonly assigned European Patent Application EP-A-612234 entitled "Sanitary Napkin Wrapper and Adhesive Tab Construction for the Same", inventors Berg et al. .

F. Elastic Material and Restraint Material

As illustrated in Figures 1 and 2, two discrete seg-

ments of an elastic material 50 are permanently secured to the exposed surface of backsheet portion 23 of the sanitary napkin 20. The preferred placement of the two segments of elastic material 50, substantially parallel to the longitudinal perimeter segments 32, is illustrated in Figure 3. Releasably secured to the segments of elastic material 50 are two segments of restraint material 52. The two segments of restraint material 52 are permanently secured to the wrapper 30. The preferred placement of the two corresponding segments of restraint material 52, substantially parallel to the longitudinal edge 35 of the wrapper 30, is illustrated in Figure 4.

The restraint material 52 releasably secures the elastic material 50 in a substantially tensioned state until separation of the elastic material 50 from the restraint material 52, whereupon the tension in the elastic material 50 is released.

While in the substantially tensioned state, the restraint material 52 and the elastic material 50 are substantially stable. The two materials can be machined, cut, and attached to other materials with little or no detrimental effect to the two materials. An example of a suitable restraint material 52 and elastic material 50 is disclosed in commonly assigned U.S. Patent 4,908,247 issued to Baird et al. on March 13, 1990. Other suitable restraint materials include, but are not limited to, polyester, polyethylene terephthalate (PET), glycol modified PET copolymer (PETG), polystyrene, blends of polystyrene and polyethylene, polyethylene, polyethylene laminated to paper, and paper. Preferably, the elastic material 50 is a material that can undergo moderate levels of reversible strain. Suitable elastic materials include, but are not limited to synthetic natural rubbers.

Upon separation of the restraint material 50 from the elastic material 50 the sanitary napkin 20 is in a substantially bi-stable state. In other words, upon separation and removal of the restraint material 52 from the elastic material 50, the sanitary napkin 20 may either form an upwardly cupped configuration or a downwardly cupped configuration under the shirring of the elastic material 50. The expected result is a downwardly cupped configuration as the elastic will naturally take the path of least resistance. However, by securing the elastic material 50 to the backsheet 23, the elastic material 50 is biased to shirr in one direction due to the direction of separation of the restraint material 52 from the elastic material 50. The separation of the restraint material 52 from the elastic material 50 releases the tension in the elastic material 50 causing the sanitary napkin 20 to become elasticized. As used herein the term "elasticized" refers to that condition where the restraint material is separated from the elastic material thereby releasing the tension in the elastic material. When the sanitary napkin 20 becomes elasticized upon the separation of the restraint material 52 from the elastic material 50, the sanitary napkin 20 forms an upwardly cupped configuration and elastically shirrs in

the direction of the tension release. This upwardly cupped configuration provides a sanitary napkin which more readily conforms to the contours of the user's body, as illustrated in Figure 6.

The degree of upwardly cupping of the sanitary napkin 20 is determined by several factors, these include, but are not limited to, the location of the elastic material, the modulus of elasticity of the elastic material, the ability of the elastic material to maintain tension for extended periods of time, thickness of the elastic material, thickness of the sanitary napkin, stiffness of the sanitary napkin, length of the elastic material, and pre-stretch of the elastic material.

The length of the elastic material 50 applied to backsheet portion 23 can effect the degree of upward cupping. The longer the length of the elastic material 50 the greater the degree of upward cupping. In addition, as the amount of pre-stretch in the elastic material 50 is increased the degree or amount of cupping is also increased. Furthermore, the stiffness and/or thickness of the sanitary napkin 20 itself, or the materials which comprise sanitary napkin 20 can also effect the degree of cupping. In other words, as the thickness and/or stiffness of the sanitary napkin 20 increases, the amount or degree of upward cupping accordingly decreases. All of the above factors can be manipulated in conjunction with one another or independently to vary the degree and amount of cupping of the sanitary napkin 20 for particular uses as determined by the maker. For example, for a sanitary napkin 20 to be used during periods of heavy menstrual flow, it may be desirable to have a thick pad having a high degree of upward cupping. Therefore, since the thick pad will be relatively resistant to cupping, the tension, length, and/or selection of material for the elastic material 50 may be varied together or independently to get the desired degree of upward cupping on the thick pad.

Figure 9 is a cross-sectional view of an alternative embodiment of a sanitary napkin 20 of the present invention. As can be seen in Figure 9 the sanitary napkin 20 preferably comprises an elastic material 50 positioned between the wrapper 30 and the backsheet 23. The elastic material 50 is permanently secured to the exposed surface of the backsheet 23. The wrapper 30 is releasably affixed to the backsheet 23. In this embodiment, the wrapper 30 maintains the elastic material 50 in a substantially tensioned state until separation of the wrapper 30 from the elastic material 50 and the backsheet 23, whereupon the tension in the elastic material 50 is released. In order for the wrapper 30 to maintain the elastic material 50 in a substantially tensioned state until manual separation of the elastic material 50 from the wrapper 30, the wrapper 30 must be sufficiently strong to maintain the tensional forces in the elastic material 50. Suitable means for providing the wrapper 30 with sufficient strength include but are not limited to polyethylene laminated to paper, and paper. In addition, the wrapper 30 may include relatively thick portions at

locations adjacent the elastic material 50. This may be accomplished by coextrusion or lamination of additional material in those isolated portions.

Figures 10 and 11 are illustrations of an alternative embodiment of a sanitary napkin 20 of the present invention. As can be seen in Figures 10 and 11, the sanitary napkin 20 preferably comprises two discrete segments of elastic material 50. Preferably the elastic material 50 is secured to the body facing surface of the backsheet 23 and also to the longitudinal segments of the absorbent core 24. In this embodiment, the wrapper 30 maintains the elastic material 50 in a substantially tensioned state until separation of the wrapper 30 from the backsheet 23, whereupon the tension in the elastic material 50 is released. As with the sanitary napkin illustrated in Figure 9, the wrapper 30 must be sufficiently strong to maintain the elastic material 50 in a substantially tensioned state.

Figures 12 and 13 illustrate another embodiment of a sanitary napkin 20 of the present invention. As can be seen Figures 12 and 13, the sanitary napkin 20 preferably comprises a first elastic material 50 and second elastic material 51 positioned between the backsheet 23 and the absorbent core 24. The elastic materials 50 and 51 are permanently secured to the wearer or body facing surface of the backsheet 23. In this embodiment, the wrapper 30 maintains the elastic materials 50 and 51 in a substantially tensioned state until separation of the wrapper 30 from the backsheet 23, whereupon the tension in the elastic materials 50 and 51 is released. Again, the wrapper 30 must be of sufficient strength to maintain the elastic materials, 50 and 51, in a tensioned state.

While particular embodiments of the present invention have been illustrated and described, it will be apparent to those skilled in the art that various other embodiments can be carried out within the scope of the present invention. For example, elastic segments may be secured to the exterior surface of the backsheet, or placed in numerous positions between the backsheet and the topsheet of the sanitary napkin. The elastic may be a singular strand or multiple strands. In addition, the elastic segments may comprise one or more materials. The elastic segments may have varying thicknesses throughout their length, thus providing varying modulus of elasticity throughout the length of the elastic material. In addition, the elastic material may be positioned in any direction desired by the maker. For example, the elastic segments may run in a transverse direction across the sanitary napkin or in a diagonal direction. Transverse elastic segments will cause the sanitary napkin to have an inwardly cupped configuration upon the release of tension in the elastic material, i.e., separation of the wrapper from the backsheet.

It is important, however, that whatever embodiment is desired that the elastic material be maintained in a substantially restrained or tensioned state until separation of the wrapper from the sanitary napkin. By main-

taining the elastic material in a substantially tensioned state, storage, packaging, and transport of the individually wrapped sanitary napkin will be greatly enhanced.

3. Use of the Sanitary Napkin

In use, an individually packaged sanitary napkin 20 as illustrated in Figure 5 is provided to the user. The user first separates the adhesive tab 44 from complementary landing member 46. The user may then break the seal between the longitudinal flap portions 32 and unfold the sanitary napkin 20 and wrapper 30 combination. The user thereafter removes the wrapper 30 from the sanitary napkin 20, thereby releasing the tension in the elastic material 50. The release of tension in the elastic material 50 causes the sanitary napkin 20 to have a generally upwardly cupped shape due to the shirring of elastic material 50, as shown in Figure 4. The sanitary napkin 20 may then be used as such devices normally are.

After use, the user can place the backsheet 23 of the sanitary napkin 20 on wrapper 30. The wrapper and pad can be folded or rolled together. Then the user can stick the adhesive tab 44 to a portion of the wrapper 30 other than complementary landing portion 46.

4. Method of Making the Sanitary Napkin of the Present Invention

Referring to Figure 14 there is shown a simplified sectional side elevation view illustrating the assembly of the sanitary napkin illustrated in Figures 1 and 2 having tensioned elastic material secured thereto. The sanitary napkin 20 which includes a liquid pervious topsheet 22, a liquid impervious backsheet 23 joined with the topsheet 22 and an absorbent core 24 positioned between the topsheet 22 and the backsheet 23 is assembled by methods commonly known in the art. The sanitary napkin may also include an acquisition layer 25 positioned between the topsheet 22 and the absorbent core 24 and a nonwoven 27 positioned between the absorbent core 24 and the backsheets 23. The assembled sanitary napkins 20 are fed towards assembly station 200 with their backsheets 23 oriented towards the assembly station 200.

Above assembly 200 is a vacuum drum 201 for combining a continuous ribbon of elastic material 250 with a continuous ribbon of restraint material 252. The elastic material 250 is fed from feed roll 210 onto the vacuum drum 201. Speed differential between the elastic supply feed roll 210 and the vacuum drum 201 is used to control the desired pre-stretch of elastic material 250 for the assembly process. The restraint material 252 is fed from feed roll 212 into heat tunnel 213 whereby the restraint 252 material is preheated. The heated restraint material 252 is then fed onto the vacuum drum 201. Combining rolls 215 around the periphery of vacuum drum 201 are heated or cooled as

needed to obtain the proper process conditions. As the vacuum drum 201 rotates, the combining rolls 215 apply pressure to the elastic material 250 and restraint material 252 thereby mechanically securing the elastic material 250 to the restraint material 252 forming a continuous ribbon 190 of tensioned elastic material and restraint material. In an alternative embodiment, the continuous ribbon 190 of tensioned elastic material and restraint material can be made off-line.

The combined ribbon of elastic material and restraint material 190 is fed toward assembly station 200 on a feminine hygiene pad converting line using known assembly technology. This operation takes place after the sanitary napkin elements (topsheet, backsheet, and core) are assembled and prior to the placement of the sanitary napkin 20 onto the wrapper material. Knife 203 cuts the combined ribbon 190 into discrete lengths (approximately 10 cm long) and using cut and slip technology places one such cut segment on each side of the backsheet 23 of the sanitary napkin 20 along the longitudinal edge as shown in Figure 3. These discrete lengths of restrained elastic material 191 are secured to the backsheet 23 of the sanitary napkin 20 by applying a coating of hot melt adhesive at glue applicator 205 to the elastic side of the restrained elastic material prior to placement on the sanitary napkin 20. The sanitary napkin 20 assembly is then fed between a set of special nip rolls 207 to both set the hot melt in place and to help cool the hot adhesive.

The next step in the assembly process of this preferred embodiment is to combine the sanitary napkin 20 assembly with the continuous web of wrapper material 230. This is accomplished by combining a continuous web of polyethylene film 230 from feed roll 211 (approximately one mill) to the stream of sanitary napkin 20 assemblies as they continue through the converting line. A party fastening adhesive (PFA) is applied intermittently to web 230 at applicator 260. Chill roll 261 prevents undesirable distortion as the heated PFA is applied to web 230. The PFA is applied to the web 230 to later be transferred to the backsheet of the absorbent article to provide securement of the article to the undergarment during use. During this combining process a permanent bond must be made between the restraint material of the previously positioned restrained elastic material and the film wrapper material 230. This permanent bond is accomplished by applying a limited amount of heat at heater bar 214 to the restraint material side of the restrained elastic material prior to combining with the wrapper film 230. The combined assembly is then passed through a heated compression station 217 to permanently bond the restraint material to the wrapper film. This permanent bond is enhanced by having a laminate restraint material that has a top surface that contains a low temperature melt surface such as an EVA copolymer material.

The wrapper material 230 on the assembled sanitary napkin structure is then cut into discrete segments

at station 220 and the sanitary napkin and wrapper assembly is rotated ninety degrees before being folded as a unit.

That is, they are folded together with the wrapper 30 remaining in place with respect to the sanitary napkin 20. Preferably, the sanitary napkin 20 is folded lengthwise into thirds about two fold-axes 60, as shown in Figure 1. The longitudinal flap portions 36 are frangibly sealed using any of the well-known sealing techniques at station 225. For example, the longitudinal flap portions 36 may be heat sealed, glued, ultrasonically bonded, or crimped or any combination thereof. The adhesive tab 44 with complementary landing member 46 is then secured to the exposed surface of the wrapper 30 at station 240. The folded and sealed sanitary napkin 20 with wrapper 30 is illustrated in Figure 5.

There are many alternative assembly methods and individual unit operations that can be employed in the construction of the present invention. For example, the combined elastic and restraint material could be placed on the sanitary napkins one at a time or could be placed on the sanitary napkins simultaneously. The combined elastic and restraint material could be supplied in a non-continuous precut form and thus eliminate the on-line cutting operation. The combined elastic and restraint material glue mounting operations could be located such that the glue were placed directly on the sanitary napkin rather than on the combined elastic and restraint material. This glue operation could also be eliminated if the combined elastic and restraint material were mounted with the use of a pressure sensitive glue or other standard mounting means. The means by which the permanent bond of the restraint portion of the combined elastic and restraint material to the wrapper film is accomplished can also incorporate the use of hot melt glue or other known permanent bonding techniques. If the finished product is to contain a panty fastening adhesive (PFA), this material can be applied to the sanitary napkin prior to the application of the combined elastic and restraint material during any part of the combined elastic and restraint material application process or it can be applied directly to the wrapper material so as to transfer to the sanitary napkin when it is combined with the sanitary napkin.

Referring now to Figure 15 there is shown a simplified sectional side elevation view illustrating the assembly of sanitary napkins of Figures 10-13 of the present invention. A web of backsheet material 323 is fed from roll 400 to nip rolls 402. A hot melt adhesive is applied to backsheet material 323 at station 305. An absorbent core 324 is then fed onto backsheet web 323 at absorbent core assembly station 380. The core material 341 is fed from the core supply roll 342, positioned above core assembly station 380, to the core assembly station 380. A continuous ribbon of elastic material 350 is fed from feed roll 310 to roller 301. Prior to reaching the web of backsheet material 323 an adhesive is applied at adhesive applicator 313 to the elastic ribbon 350. After adhe-

sive is applied to elastic ribbon 350, it is fed to rolls 404 and 406. The speed differential between feed roll 310 and roll 301 controls the desired prestretch for the elastic ribbon 350. The elastic ribbon 350 is intermittently glued to the backsheet material 323. The elastic material may also be glued to the absorbent core 324. A knife 303 severs or cuts the ends of the continuous elastic ribbon 350 thereby providing discrete segments. An acquisition layer 325 is then placed upon the absorbent core 324 directly below acquisition layer assembly station 382. Directly above acquisition layer assembly station 382 is an acquisition layer feed roll 340 which feeds acquisition material 343 to assembly station 382. A continuous ribbon of topsheet material 322 is fed from roll 408 toward roller 410. The topsheet material 322 is then secured to the backsheet material 323 at station 375. The sanitary napkin is cut into its final shape by cutter 378. The sanitary napkin is then fed to assembly station 315.

Simultaneously, a continuous web of wrapper material 330 is fed from roll 311 to assembly station 314. A continuous ribbon of stiffening material 370 is fed from roll 412 towards assembly station 314. The stiffening material 370 is secured to the continuous wrapper material 330 at station 314. A layer of release coating is applied to the wrapper material 330 at station 328. The wrapper assembly is then fed toward combining station 315.

In an alternative embodiment, a continuous web of release paper 432 is fed from roll 430 to station 434. At station 434 the web of release paper 432 is intermittently applied to the web of wrapper material 330. Preferably, PFA may be applied intermittently to the release paper 432 prior to reaching station 434.

At combining station 315 the sanitary napkin is then attached to the wrapper material 330. A vacuum maintains the elastic material in a substantially tensioned state until the wrapper is attached to the backsheet. A knife 317 cuts the wrapper material into discrete segments. At station 373 a folding crimping operation of the wrapper sanitary napkin assembly occurs. A continuous roll of releasable tape 344 is fed from roll 415 and is attached to the outer surface of the folded individually wrapped package at station 319.

By maintaining the sanitary napkin 20 in a substantially flat configuration, the sanitary napkin 20 may be packaged, transported, shipped, and handled in a more convenient less bulky manner as compared to one having a curved configuration as in prior art sanitary napkins which have one or more elastic members located within the sanitary napkin itself.

Claims

1. A method for continuously attaching discrete segments of a tensioned elastic material to predetermined, isolated portions of moving absorbent articles (20), said absorbent articles (20) having a

topsheet (22), a backsheet (23), and an absorbent core (24), said method comprising the steps of:

- (a) feeding an assembled sanitary napkin (20) to a first assembly station (200);
 - (b) feeding a ribbon of stretched elastic material (250) to said first assembly station (200);
 - (c) adhering discrete segments of a tensioned elastic material (250) to said backsheet (23) at said first assembly station, said tensioned elastic material (250) being held in tension by a restraint material (252);
 - (d) feeding a continuous web of wrapper material (230) to a second assembly station;
 - (e) applying a panty fastening adhesive intermittently to said continuous web of wrapper material (230);
 - (f) securing said continuous web of wrapper material (230) to said backsheet (23) and said restraint material (252) to form a sanitary napkin assembly;
 - (g) cutting said continuous web of wrapper material (230) into discrete lengths;
 - (h) folding said sanitary napkin (20) and wrapper (230) assembly; and
 - (i) sealing said wrapper (230).
2. The method of Claim 1, further comprising the step of securing a ribbon of restraint material (252) to said ribbon of elastic material (250), said restraint material (252) maintaining said ribbon of elastic material (250) in a substantially tensioned state.
 3. The method of Claim 2, further comprising the step of cutting the ribbon of tensioned elastic material (250) into discrete segments.
 4. The method of Claim 1, further comprising the step of securing an adhesive tab (44) and a complementary landing member (46) to the exposed surface of said wrapper (230).
 5. The method of any one of the preceding Claims, wherein said tensioned elastic material (250) is adhered to said backsheet (23) of said absorbent article (20) with an adhesive.
 6. The method of any one of the preceding Claims, wherein said wrapper (230) is adhered to the restraint material (252) with an adhesive.
 7. The method of any one of the preceding Claims, wherein said absorbent article (20) and said wrapper (230) are folded about at least two fold-axes.
 8. The method of any one of the preceding Claims, wherein the wrapper (230) is frangably sealed about the longitudinal side flap portions.

9. A method for continuously attaching discrete segments of a stretched elastic material to predetermined, isolated portions of moving absorbent articles (20), said absorbent articles (20) having a topsheet (322), a backsheet (323), and an absorbent core (324) said method comprising the steps of:

- (a) feeding a continuous web of backsheet material (323) to an assembly station;
- (b) securing an absorbent core (324) to said continuous web of backsheet material (323);
- (c) securing intermittent portions of a continuous ribbon of stretched elastic material (350) to said backsheet (323) at predetermined discrete locations;
- (d) cutting said ribbon of elastic (350) material at predetermined locations;
- (e) maintaining said backsheet (323) and the stretched elastic material (350) in a substantially tensioned state;
- (f) feeding a continuous web of topsheet material (322) to said assembly station;
- (g) securing said topsheet web (322) to said backsheet web (323);
- (h) cutting said continuous web of absorbent articles into discrete absorbent articles (20);
- (i) maintaining said absorbent articles (20) in a substantially tensioned state;
- (j) feeding a continuous web of wrapper material (330) to a second assembly station;
- (k) adhering discrete portions of stiffening material (370) to said continuous web of wrapper material (330);
- (l) applying a panty fastening adhesive (28) to said continuous web of wrapper material (330);
- (m) feeding said absorbent articles (20) onto said continuous web of wrapper material (330); and
- (n) adhering said absorbent articles (20) to said wrapper material (330), said wrapper (330) maintaining said absorbent articles (20) in a substantially tensioned state.

10. The method of Claim 9, wherein said stiffening material (370) is adhered to said wrapper (330) with an adhesive.

11. The method of Claim 9, further comprising the step of folding said absorbent article (20) and said wrapper (330) as a unit about at least two fold-axes.

12. The method of Claim 11, further comprising the step of frangably sealing the longitudinal side flap portions of said wrapper (330).

Patentansprüche

1. Ein Verfahren zum kontinuierlichen Fixieren diskre-

- ter Segmente eines unter Zugspannung gesetzten elastischen Materials an vorher festgelegten, isolierten Abschnitten von sich bewegenden absorbierenden Artikeln (20), wobei die genannten absorbierenden Artikel (20) ein Deckblatt (22), ein Rückenblatt (23) und einen absorbierenden Kern (24) umfassen, wobei das genannte Verfahren folgende Schritte umfaßt:
- a) Zuführen einer zusammengesetzten Hygienevorlage (20) zu einer ersten Montagestation (200);
 - b) Zuführen eines Bandes von gestrecktem elastischen Material (250) zur genannten ersten Montagestation (200);
 - c) haftendes Anbringen diskreter Segmente eines unter Zugspannung gesetzten elastischen Materials (250) an das genannte Rückenblatt (23) an der genannten ersten Montagestation, wobei das genannte unter Zugspannung gesetzte elastische Material (250) durch ein Rückhaltematerial (252) unter Zugspannung gehalten wird;
 - d) Zuführen einer kontinuierlichen Bahn aus Hüllenmaterial (230) zu einer zweiten Montagestation;
 - e) Aufbringen eines Höschchenbefestigungsklebstoffs intermittierend auf die genannte kontinuierliche Bahn von Hüllenmaterial (230);
 - f) Fixieren der genannten kontinuierlichen Bahn aus Hüllenmaterial (230) an dem genannten Rückenblatt (23) und dem genannten Rückhaltematerial (252), um einen Hygienevorlagenaufbau zu bilden;
 - g) Schneiden der genannten kontinuierlichen Bahn aus Hüllenmaterial (230) in diskrete Längen;
 - h) Falten des genannten Aufbaus aus Hygienevorlage (20) und Hülle (230); und
 - i) Siegeln der genannten Hülle (230.)
2. Das Verfahren nach Anspruch 1, welches weiters den Schritt des Fixierens eines Bandes von Rückhaltematerial (252) am genannten Band aus elastischem Material (250) umfaßt, wobei das genannte Rückhaltematerial (252) das genannte Band aus elastischem Material (250) in einem im wesentlichen unter Zugspannung gesetzten Zustand hält.
 3. Das Verfahren nach Anspruch 2, welches weiters den Schritt des Schneidens des Bandes von unter Zugspannung gesetztem elastischen Material (250) in diskrete Segmente umfaßt.
 4. Das Verfahren nach Anspruch 1, welches weiters den Schritt des Fixierens einer Klebelasche (44) und eines komplementären Auftreffbauteils (46) an der exponierten Oberfläche der genannten Hülle (230) umfaßt.
 5. Das Verfahren nach einem der vorhergehenden Ansprüche, bei welchem das genannte unter Zugspannung gesetzte elastische Material (250) am genannten Rückenblatt (23) des genannten absorbierenden Artikels (20) mit einem Klebstoff angeheftet wird.
 6. Das Verfahren nach einem der vorhergehenden Ansprüche, bei welchem die genannte Hülle (230) am genannten Rückhaltematerial (252) mit einem Klebstoff angeheftet wird.
 7. Das Verfahren nach einem der vorhergehenden Ansprüche, bei welchem der genannte absorbierende Artikel (20) und die genannte Hülle (230) um mindestens zwei Faltungsachsen gefaltet werden.
 8. Das Verfahren nach einem der vorhergehenden Ansprüche, bei welchem die Hülle (230) um die Längsseitenlappenabschnitte brechbar gesiegelt wird.
 9. Ein Verfahren zum kontinuierlichen Fixieren diskreter Segmente eines gestreckten elastischen Materials an vorher festgelegten, isolierten Abschnitten von sich bewegenden absorbierenden Artikeln (20), wobei die genannten absorbierenden Artikel (20) ein Deckblatt (322), ein Rückenblatt (323) und einen absorbierenden Kern (324) aufweisen, wobei das genannte Verfahren folgende Schritte umfaßt:
 - a) Zuführen einer kontinuierlichen Bahn von Rückenblattmaterial (323) zu einer Montagestation;
 - b) Fixieren eines absorbierenden Kerns (324) an der genannten kontinuierlichen Bahn von Rückenblattmaterial (323);
 - c) Fixieren intermittierender Abschnitte eines kontinuierlichen Bandes aus gestrecktem elastischen Material (350) am genannten Rückenblatt (323) an vorher festgelegten diskreten Stellen;
 - d) Schneiden des genannten Bandes aus elastischem Material (350) an vorher festgelegten Stellen;
 - e) Halten des genannten Rückenblatts (323) und des gestreckten elastischen Materials (350) in einem im wesentlichen unter Zugspannung gesetzten Zustand;
 - f) Zuführen einer kontinuierlichen Bahn aus Deckblattmaterial (322) zur genannten Montagestation;
 - g) Fixieren der genannten Deckblattbahn (322) an der genannten Rückenblattbahn (323);
 - h) Schneiden der genannten kontinuierlichen Bahn von absorbierenden Artikeln in diskrete

absorbierende Artikel (20);

i) Halten der genannten absorbierenden Artikel (20) in einem im wesentlichen unter Zugspannung gesetzten Zustand;

j) Zuführen einer kontinuierlichen Bahn von Hüllenmaterial (330) zu einer zweiten Montagestation; 5

k) Anheften diskreter Abschnitte von versteifendem Material (370) an der genannten kontinuierlichen Bahn aus Hüllenmaterial (330); 10

l) Aufbringen eines Höschenbefestigungsklebstoffs (28) an der genannten kontinuierlichen Bahn aus Hüllenmaterial (330);

m) Zuführen der genannten absorbierenden Artikel (20) auf die genannte kontinuierliche Bahn aus Hüllenmaterial (330); und 15

n) Anheften der genannten absorbierenden Artikel (20) an das genannte Hüllenmaterial (330), wobei die genannte Hülle (330) die genannten absorbierenden Artikel (20) in einem im wesentlichen unter Zugspannung gesetzten Zustand hält. 20

10. Das Verfahren nach Anspruch 9, bei welchem das genannte Versteifungsmaterial (370) an der genannten Hülle (330) mit einem Klebstoff angeheftet wird. 25

11. Das Verfahren nach Anspruch 9, welches weiters den Schritt des Faltens des genannten absorbierenden Artikels (20) und der genannten Hülle (330) als eine Einheit um mindestens zwei Faltungsachsen umfaßt. 30

12. Das Verfahren nach Anspruch 11, welches weiters den Schritt des lösbaren Siegelns der Längsseitenlappenabschnitte der genannten Hülle (330) umfaßt. 35

Revendications 40

1. Procédé pour fixer en continu des segments discrets d'un matériau élastique tendu à des parties prédéterminées, isolées, d'articles absorbants (20) se déplaçant, lesdits articles absorbants (20) présentant une feuille de dessus (22), une feuille de fond (23) et une âme absorbante (24), ledit procédé comprenant les étapes consistant à : 45

(a) acheminer une serviette hygiénique (20) assemblée vers un premier poste d'assemblage (200); 50

(b) acheminer un ruban de matériau élastique (250) étiré vers ledit premier poste d'assemblage (200); 55

(c) faire adhérer des segments discrets d'un matériau élastique (250) tendu à ladite feuille de fond (23) au niveau dudit premier poste

d'assemblage, ledit matériau élastique (250) tendu étant maintenu tendu par un matériau de retenue (252);

(d) acheminer une bande continue de matériau d'enveloppe (230) vers un deuxième poste d'assemblage;

(e) appliquer de manière intermittente un adhésif de fixation de culotte à ladite bande continue de matériau d'enveloppe (230);

(f) assujettir ladite bande continue de matériau d'enveloppe (230) à ladite feuille de fond (23) et audit matériau de retenue (252) afin de former un ensemble de serviette hygiénique;

(g) couper ladite bande continue de matériau d'enveloppe (230) en longueurs discrètes;

(h) plier ledit ensemble de serviette hygiénique (20) et d'enveloppe (230); et

(i) fermer hermétiquement ladite enveloppe (230).

2. Procédé selon la revendication 1, comprenant, en outre, l'étape consistant à assujettir un ruban de matériau de retenue (252) audit ruban de matériau élastique (250), ledit matériau de retenue (252) maintenant ledit ruban de matériau élastique (250) dans un état sensiblement tendu.

3. Procédé selon la revendication 2, comprenant, en outre, l'étape consistant à couper le ruban de matériau élastique (250) tendu en segments discrets.

4. Procédé selon la revendication 1, comprenant, en outre, l'étape consistant à assujettir une patte adhésive (44) et un élément de réception (46) complémentaire à la surface exposée de ladite enveloppe (230).

5. Procédé selon l'une quelconque des revendications précédentes, dans lequel ledit matériau élastique (250) tendu adhère à ladite feuille de fond (23) dudit article absorbant (20) grâce à un adhésif.

6. Procédé selon l'une quelconque des revendications précédentes, dans lequel ladite enveloppe (230) adhère au matériau de retenue (252) grâce à un adhésif.

7. Procédé selon l'une quelconque des revendications précédentes, dans lequel ledit article absorbant (20) et ladite enveloppe (230) sont pliés autour d'au moins deux axes de pliage.

8. Procédé selon l'une quelconque des revendications précédentes, dans lequel l'enveloppe (230) est fermée hermétiquement de façon frangible autour des parties de rabat latéral longitudinal.

9. Procédé pour fixer en continu des segments dis-

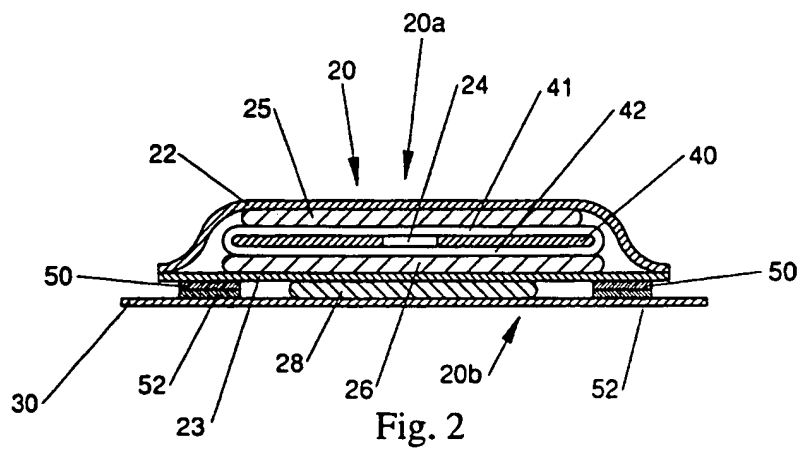
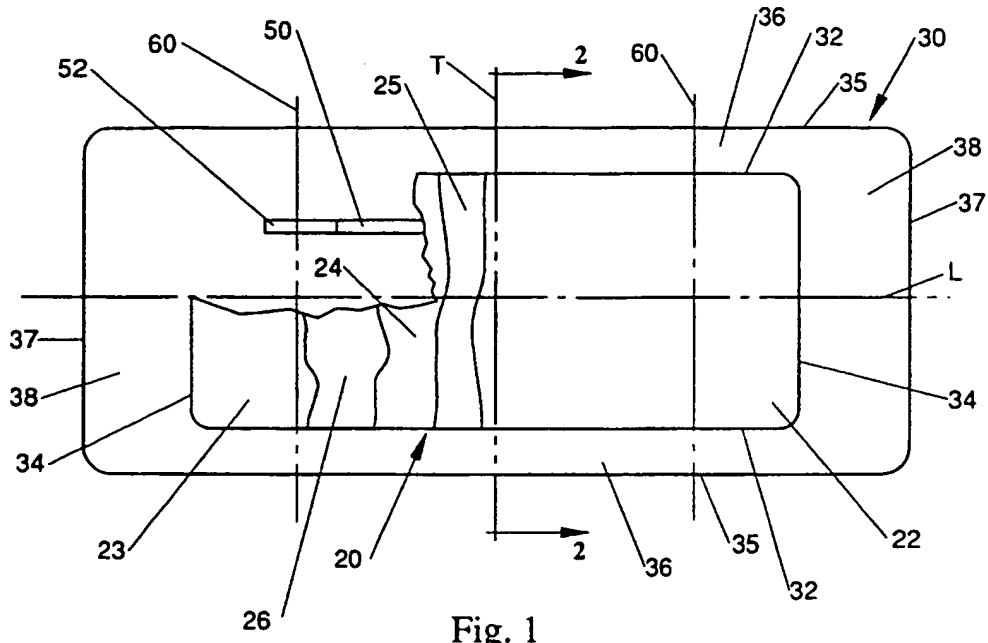
crets d'un matériau élastique étiré à des parties prédéterminées, isolées, d'articles absorbants (20) se déplaçant, lesdits articles absorbants (20) présentant une feuille de dessus (322), une feuille de fond (323) et une âme absorbante (324), ledit procédé comprenant les étapes consistant à :

- (a) acheminer une bande continue de matériau de feuille de fond (323) vers un poste d'assemblage; 10
- (b) assujettir une âme absorbante (324) à ladite bande continue de matériau de feuille de fond (323);
- (c) assujettir des parties intermittentes d'un ruban continu de matériau élastique (350) étiré à ladite feuille de fond (323) en des emplacements discrets prédéterminés 15
- (d) couper ledit ruban de matériau élastique (350) en des emplacements prédéterminés;
- (e) maintenir ladite feuille de fond (323) et le matériau élastique (350) étiré dans un état sensiblement tendu; 20
- (f) acheminer une bande continue de matériau de feuille de dessus (322) vers ledit poste d'assemblage; 25
- (g) assujettir ladite bande de feuille de dessus (322) à ladite bande de feuille de fond (323);
- (h) couper ladite bande continue d'articles absorbants en articles absorbants (20) discrets; 30
- (i) maintenir lesdits articles absorbants (20) dans un état sensiblement tendu;
- (j) acheminer une bande continue de matériau d'enveloppe (330) vers un deuxième poste d'assemblage; 35
- (k) faire adhérer des parties discrètes de matériau de renforcement (370) à ladite bande continue de matériau d'enveloppe (330);
- (l) appliquer un adhésif (28) de fixation de culotte à ladite bande continue de matériau d'enveloppe (330); 40
- (m) acheminer lesdits articles absorbants (20) sur ladite bande continue de matériau d'enveloppe (330); et
- (n) faire adhérer lesdits articles absorbants (20) audit matériau d'enveloppe (330), ladite enveloppe (330) maintenant lesdits articles absorbants (20) dans un état sensiblement tendu. 45

50

- 10. Procédé selon la revendication 9, dans lequel ledit matériau de renforcement (370) adhère à ladite enveloppe (330) grâce à un adhésif.
- 11. Procédé selon la revendication 9, comprenant, en outre, l'étape consistant à plier ledit article absorbant (20) et ladite enveloppe (330) comme une unité autour d'au moins deux axes de pliage. 55

- 12. Procédé selon la revendication 11, comprenant, en outre, l'étape consistant à fermer hermétiquement de façon frangible les parties de rabat latéral longitudinal de ladite enveloppe (330).



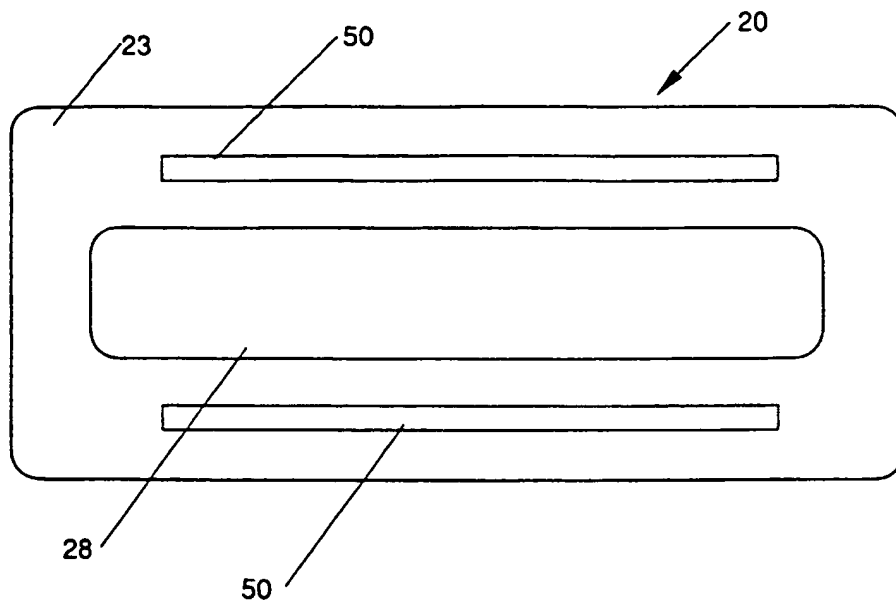


Fig. 3

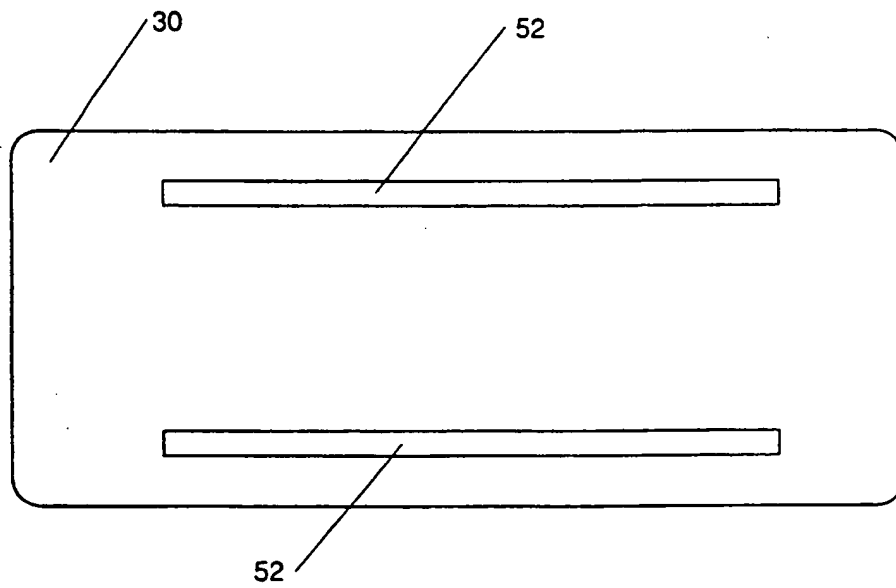


Fig. 4

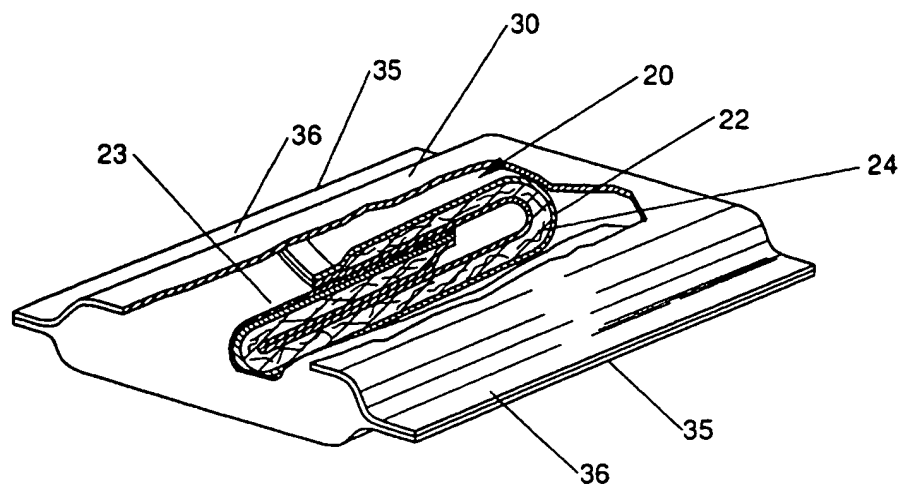


Fig. 5

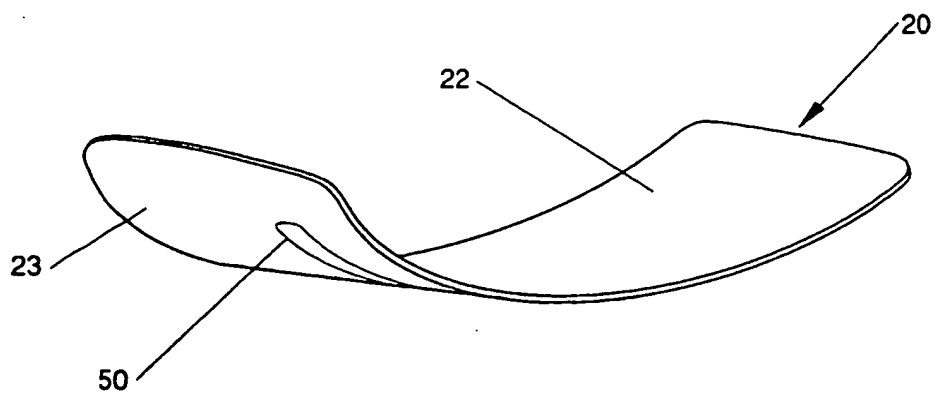


Fig. 6

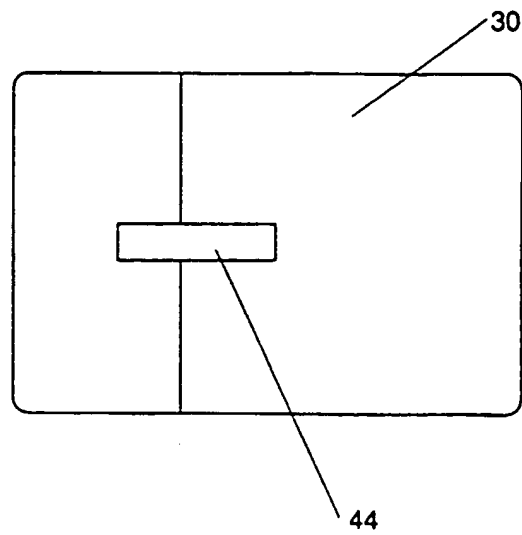


Fig. 7

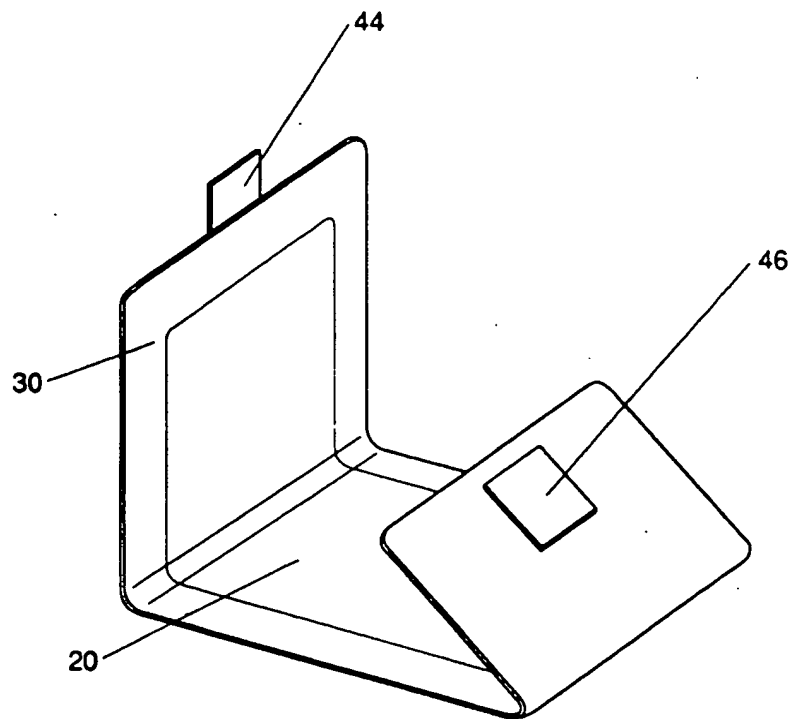


Fig. 8

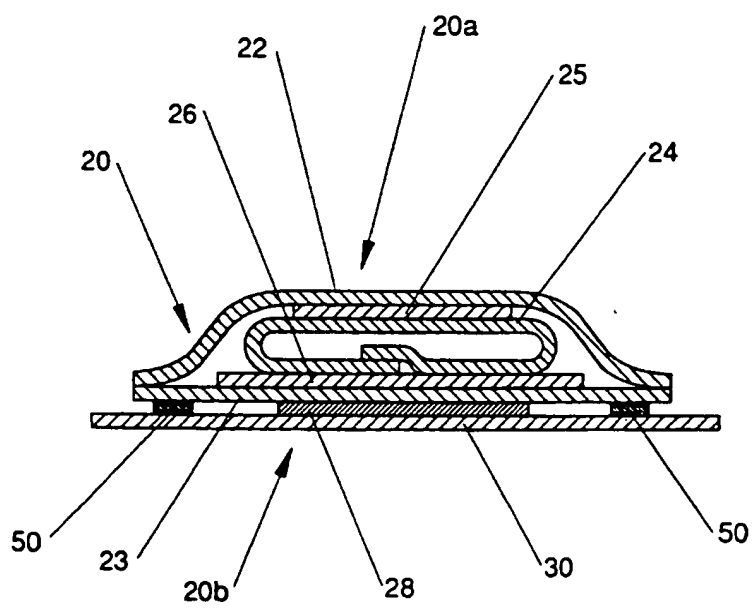


Fig. 9

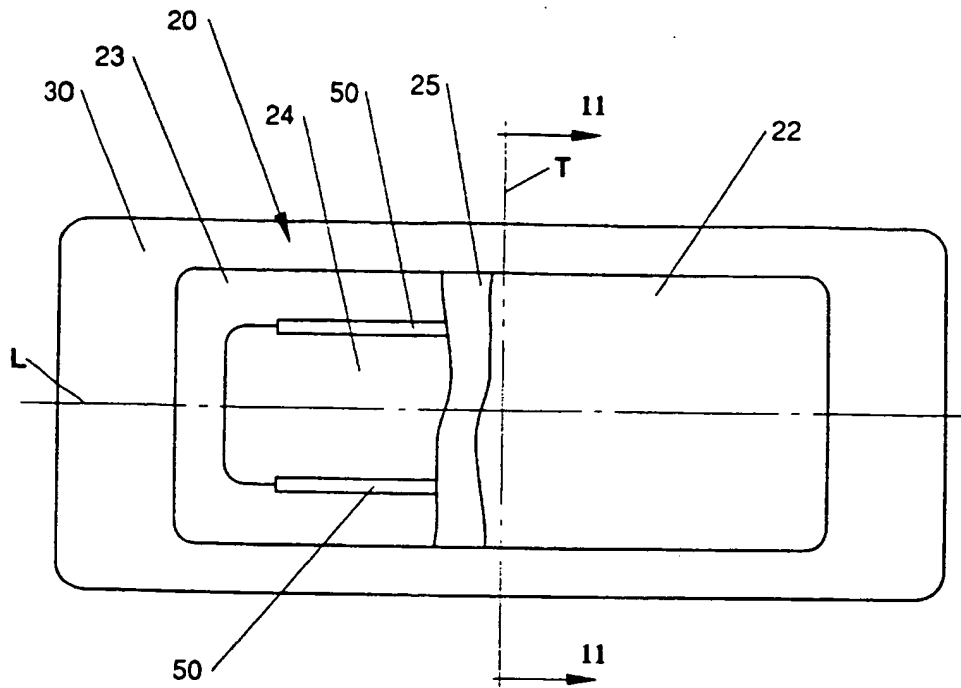


Fig. 10

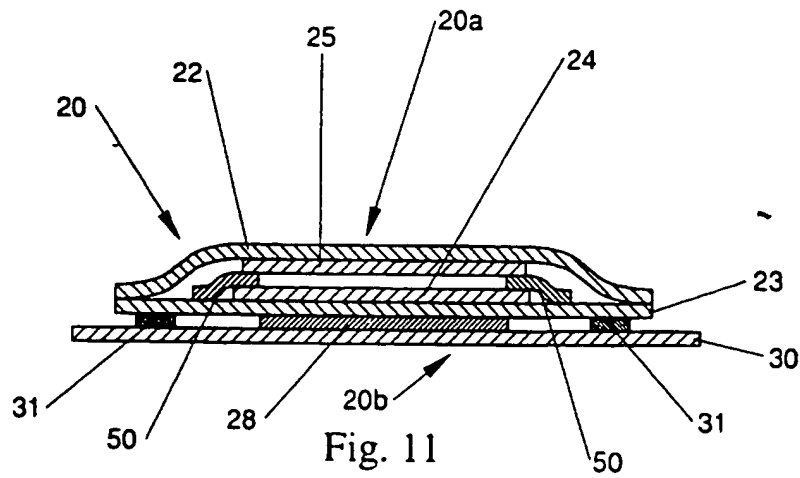


Fig. 11

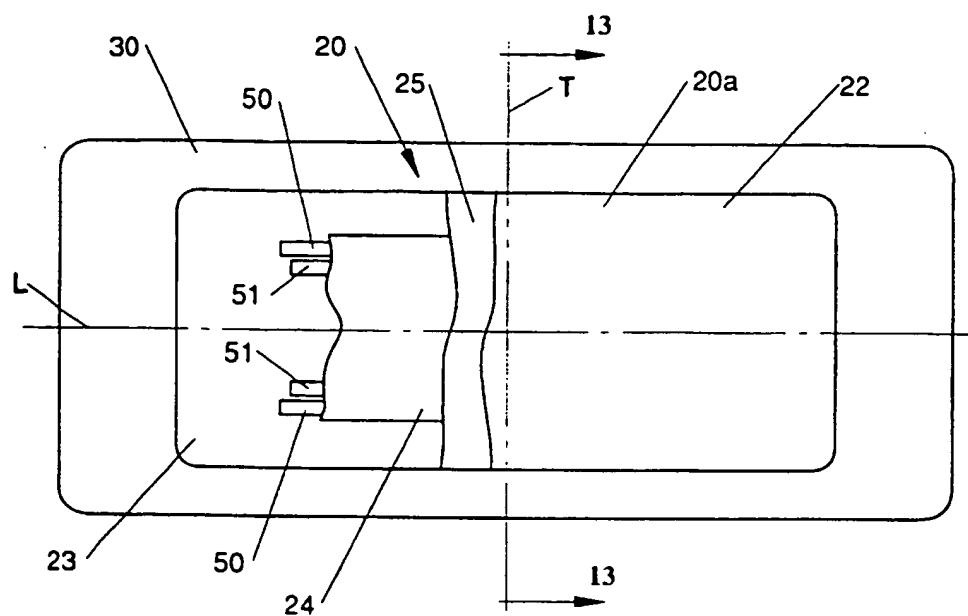


Fig. 12

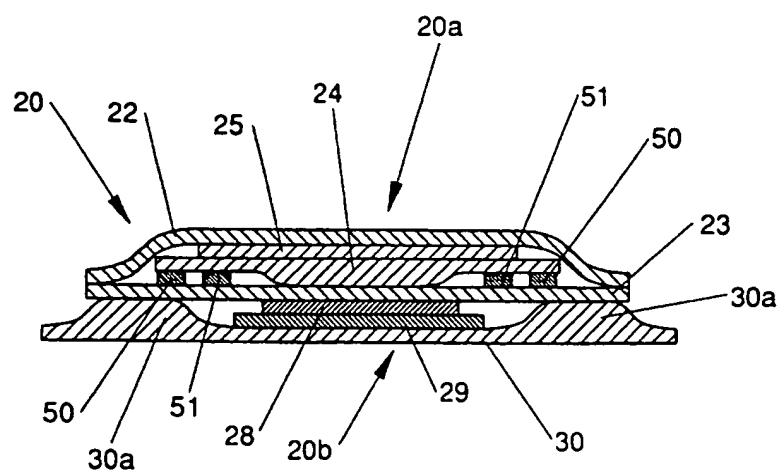


Fig. 13

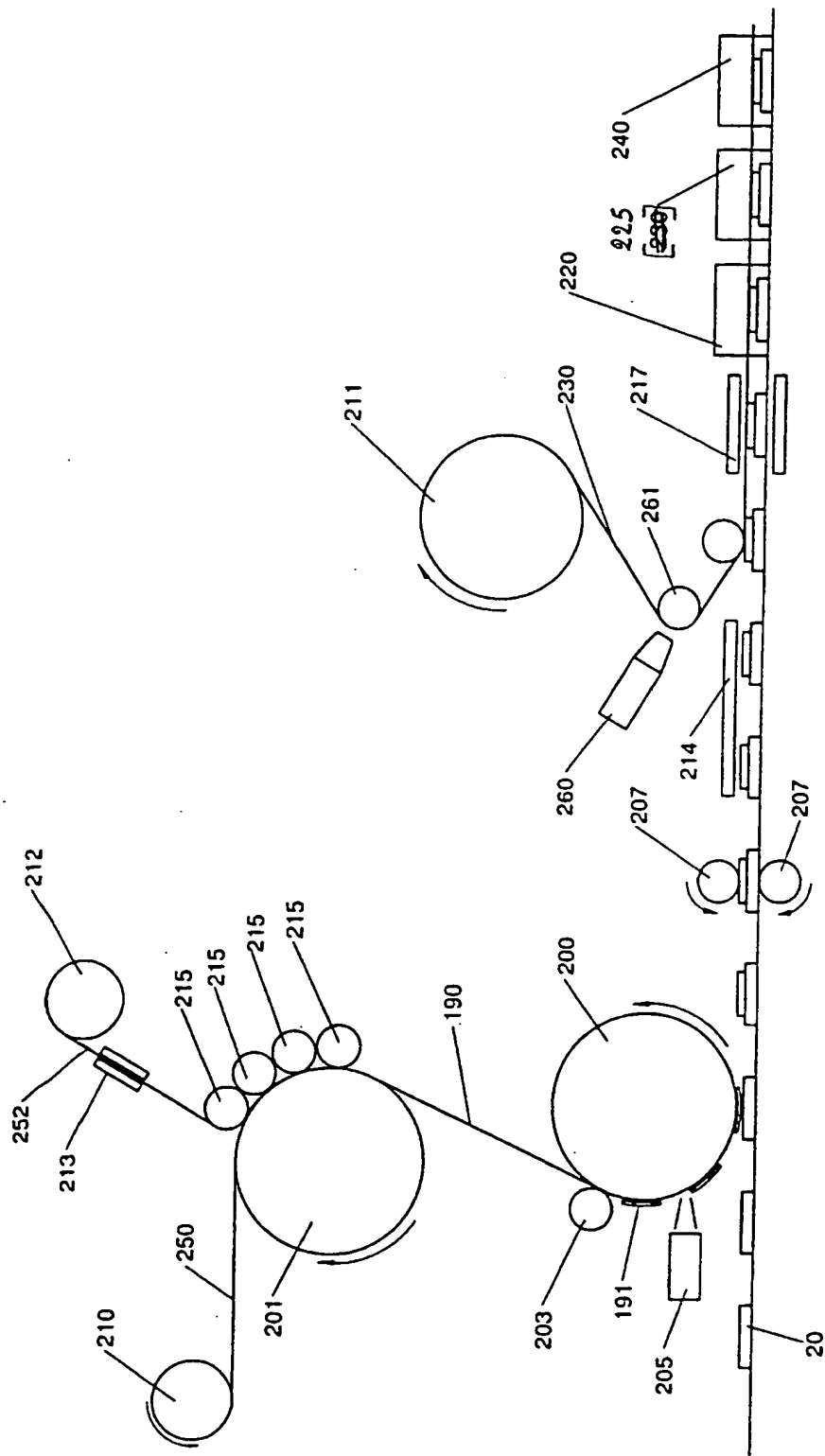


Fig. 14

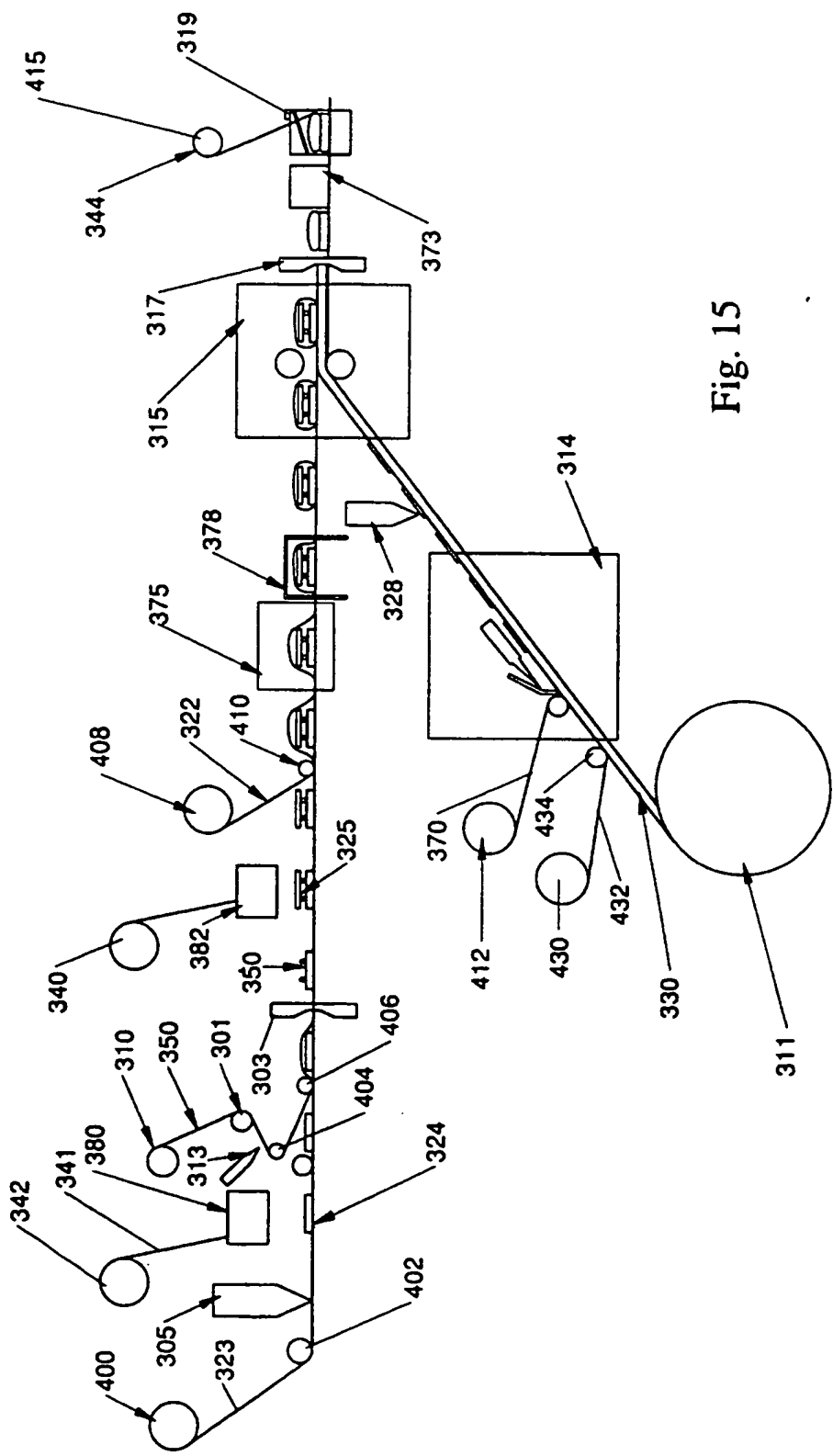


Fig. 15